

6061T6 34

Split - 2

Work Order ID 125903 - 2

Friday, October 24, 2014 11:12:01 AM

125903

Page 1

Item ID: D3490-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Cross Bolt Spacer

Stop

NS2

Start Date: 10/27/14

Start Qty: 220.00

110
220

Required Date: 11/28/14

Req'd Qty: 220.00

220

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: *MA*

Date: 14-10-24 Tooling: _____ Date: _____

Run Start

NR1

QC: _____

Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3490	Rev A								

100

100

Hardinge.CNC.LATHE.SMALL

DAS
40
9-89DAS
37 14-11-25
9-89 14-10-31

9-89

Hardinge

Hardinge CNC Lathe Small

Memo 0.00
1-TURN AS PER FOLIO FA629 & DWG D3490
FOLIO REV: *AA*
DWG REV: *A*
2-DEBURR AS REQUIRED

14/11/11

JFC 2014-11-21

110

110

QC2- Inspect parts off machine FAI/FAIB

0.00

DAS
37 14-11-25
9-89 14-10-31

QC

Quality Control

0.00

116 ♂

120

120

QC8- Inspect parts - second check

0.00

DAS
40
9-89

QC

Quality Control

0.00

116 ♂

14/11/26

485

Work Order ID 125903

Friday, October 24, 2014 11:12:01 AM

125903

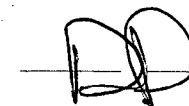
Page 2

Item ID: D3490-3 Accept *N900040100* Setup Start *NS1*
Revision ID:
Item Name: Cross Bolt Spacer Stop *NS2*
Start Date: 10/27/14 Start Qty: 220.00 *220* Cust Item ID:
Required Date: 11/28/14 Req'd Qty: 220.00 *220* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
124 *124* HandFinish	Memo CLEAN CROSSBOLT SPACER WITH ALUMINUM CLEANNER	0.00						116	Ø 14-12-05

126
126
QC
Quality Control

QC5- Inspect part completeness to step on W/O	0.00	 14-12-05
Memo	0.00	

130
130
Packaging
Packaging

Identify as per dwg & Stock Location: <u>16001</u>	0.00	 14-12-05
Memo	0.00	
STOCK IN SKIDTUBE CELL		



Work Order ID 125903

Friday, October 24, 2014 11:12:01 AM

125903

Page 3

Item ID: D3490-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Cross Bolt Spacer

Stop

NS2

Start Date: 10/27/14 Start Qty: 220.00

220

Cust Item ID:

Required Date: 11/28/14 Req'd Qty: 220.00

220

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

140

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

14/12/8 JJ

MM-12-05



Picklist Print

Page 1

Friday, October 24, 2014 11:12:05 AM

Work Order ID: 125903

125903

Parent Item: D3490-3

D3490-3

Parent Item Name: Cross Bolt Spacer

Start Date: 10/27/14

Required Date: 11/28/14

Start Qty: 220.00

Required Qty: 220.00

Comments: IPP Rev:A New Issue 06-03-03 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.750		Purchased	No			100	f	53.4941	0.266	62		DAS 37 9-89	14-10-31

M6061T6R0 750

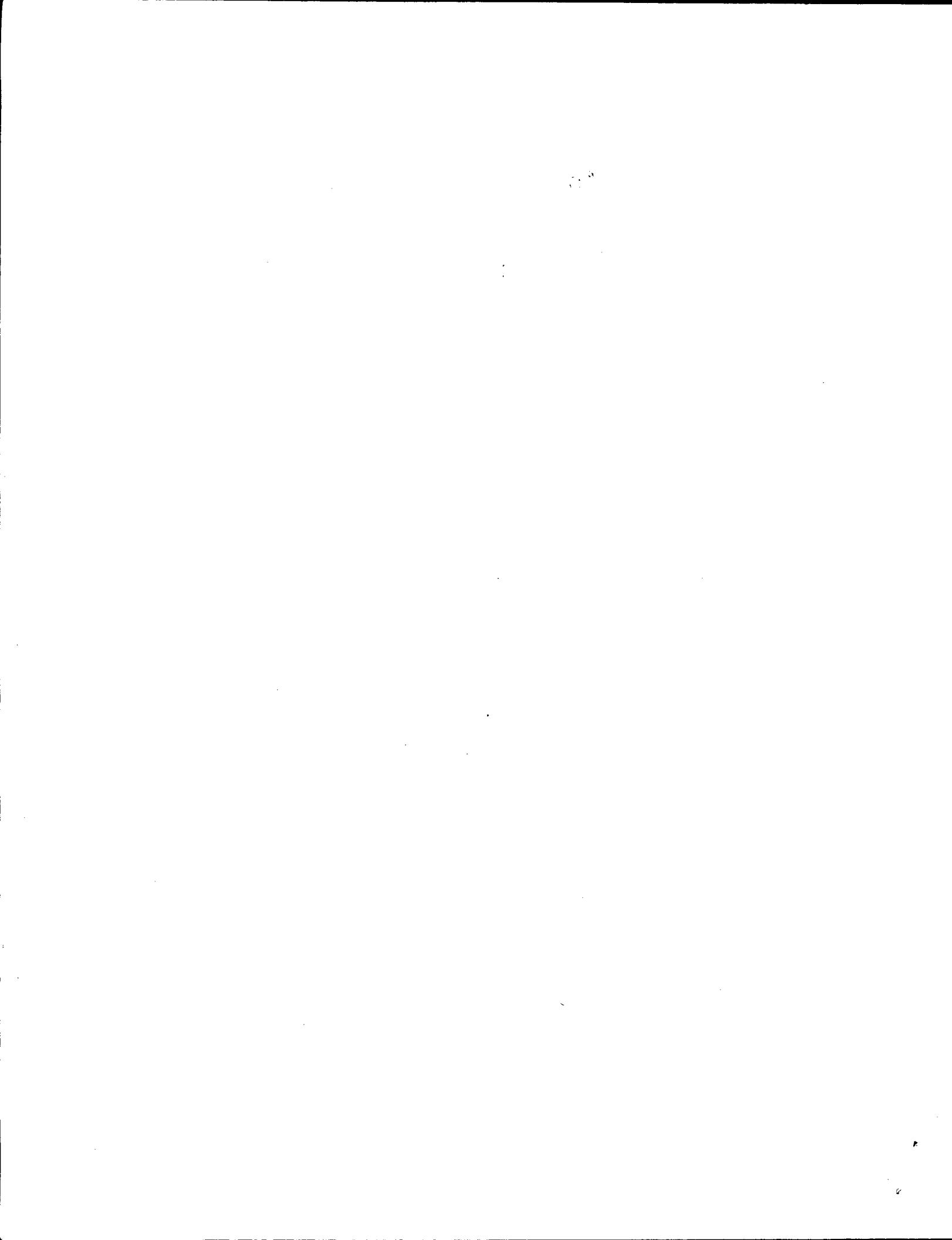
6061-T6 Round Bar .750"

Location	Loc Qty	Loc Code
MAT012	53.494052	
m126852	3.494052	
m130043	2	
m130527	48	
M130745		
M128573		

1.0 ft.
30.4 ft.
29.6 ft.
1.0 ft.

M130043 1.0 ft.
M128573 1.0 ft.
M130745 12.0 ft. - 12 ft 5.6 ft.

M130527 1.0 ft.
6.0 ft.
4.0 ft.
2.0 ft.
12.0 ft.
~~12.0 ft.~~



DART AEROSPACE LTD		Work Order:	125903
Description: Crossbolt Spacer		Part Number:	D3490-3
Inspection Dwg: D3490	Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

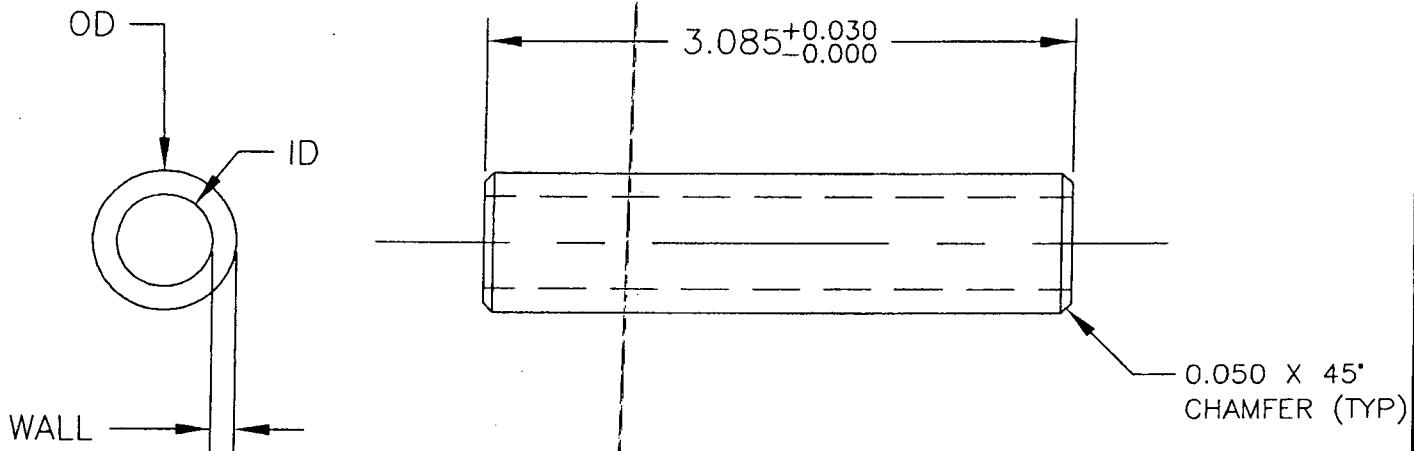
DAS	DAS		
Measured by:	37 9-89	Audited by:	40 9-89
Date:	14/10/31	Date:	14/11/16

Rev	Date	Change	Revised by	Approved
A	06.10.27	New Issue	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>



DART

DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>M</i>	APPROVED <i>M</i>	DRAWING NO. D3490	REV. A SHEET 1 OF 1
DATE 06.01.04		TITLE CROSS BOLT SPACER	SCALE NTS
A	06.01.04	NEW ISSUE	

**D3490-1/-3/-5 CROSS BOLT SPACER PARTS LIST**

PART NUMBER	OD	WALL	ID (REF)	MATERIAL SPEC
D3490-1	0.500	0.049	0.402	M6061T6T0.500W.049
D3490-3	0.750	0.080	0.591	M6061T6R0.750
D3490-5	0.313	0.058	0.197	M6061T6T0.313W.058

D3490-1/-3/-5 CROSS BOLT SPACER

- 1) MATERIAL: ALUMINUM 6061-T6 (QQ-A-200/8 OR QQ-A-225/8)
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

*PH-10-24
125903***RELEASED**
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